



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3204-041
Job Sheet 179749



Part No: D3204-041

Job Qty: 5 ea *DAS 21 6-89*

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		7/18/18	0.00	0.00	Start Up Large Fab-1		<i>Q</i>
100	Large Fab	5 pcs		7/18/18	0.00	6.49	Large Fab 8		<i>Q</i>
110	QC	5 pcs		7/18/18	0.00	0.00	QC9		<i>CPC</i>
120	QC	5 pcs		7/18/18	0.00	0.00	QC5		<i>CPC</i>
130	HandFinish	5 pcs		7/18/18	0.00	0.47	HandFinish1		<i>SA 18-08-24</i>
140	Powdercoat	5 pcs		7/18/18	0.00	0.37	Powdercoat3		<i>SA 18-09-26</i>
150	QC	5 pcs		7/18/18	0.00	0.00	QC3		<i>Q</i>
160	Small Fab	5 pcs		7/18/18	0.00	0.33	Small Fab-3		<i>DAS 38</i>
170	QC	5 pcs		7/18/18	0.00	0.00	QC5		<i>DAS 38</i>
180	Packaging	5 pcs		7/18/18	0.00	0.00	Packaging3-1		<i>SEP 11 2018</i>
190	QC21-SA	5 Ea		7/18/18	0.00	0.00	QC21		<i>SEP 11 2018</i>

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1, 3, 5, 13-199g
Descriptions: number DT10295 for tacking parts together. 3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods... 4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal. 5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps... *400*

140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: *320* FINISH TIME: *9:30*

180 - LOCATION : GA

M 136570

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	5 Ea (1 ea)	90-Start up Operation	<i>F160375</i>
D3204-11	Plate	5 Ea (1 ea)	90-Start up Operation	<i>5053627</i>
D3204-13	Gusset	10 Ea (2 ea)	90-Start up Operation	<i>5049029 110</i>
D3204-3	Arm	5 Ea (1 ea)	90-Start up Operation	<i>5089779</i>
D3204-5	Arm	5 Ea (1 ea)	90-Start up Operation	<i>5089486</i>
D3204-9	Pedal	5 Ea (1 ea)	90-Start up Operation	<i>5055732</i>
D3204-7	Bushing	10 Ea (2 ea)	160-Small Fab	<i>F156248</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3204-1	5	15	0
	D3204-11	5	8	0
	D3204-13	10	20	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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	D3204-3	5	0	0
	D3204-5	5	1	0
	D3204-9	5	6	0
160-Small Fab	D3204-7	10	21	0

Part Specifications

Specifications could not be found.

Plex 6/21/18 7:50 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / I

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐
Part No. _____		
NCR No. _____		

Date : _____ Step #: _____ QTY Effective : _____

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval
		MRB (QS1042) Approval

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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Part: D3204-041
Job No: 179749
Serial No/Batch: S104723

Container No: S104723



Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 08/23/18